



Dart Aerospace Ltd.
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D3565-1
Job Sheet 190177-A



Part No: D3565-1

Job Qty: 6 pcs

Part Name: Wearplate



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/1/19

Job Tracking No:

Due Date: 2/22/19

Created By: Eric Larocque

Type: SOLD

Description:

Note: DWG REV C IPP Rev :A New Issue 07-01-16 JLM IPP rev B revB dwg 07.04.18 ec IPP Rev:C rev.c as per
dwg 08-01-14 DD verified by: IPP Rev: D QC5 added to step 8 08.12.22 KJ Verified by:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
120	QC 8	6 pcs	2/22/19	2/22/19	0.00	0.00	QC 8 - 1 (A)		
130	Large Fab - Welded Assy-2-B4B	6 pcs	2/22/19	2/22/19	0.00	5.36	Large Fab - 1 - B4B		ER
							Large Fab - 10 - B4B		
							Large Fab - 2 - B4B		
							Large Fab - 3 - B4B		
							Large Fab - 4 - B4B		
							Large Fab - 5 - B4B		
							Large Fab - 6 - B4B		
							Large Fab - 7 - B4B		
							Large Fab - 8 - B4B		
							Large Fab - 9 - B4B		
140	QC 9	6 pcs	2/22/19	2/22/19	0.00	0.00	QC 9 - 10		APR 01 2019
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		
150	QC 5	6 pcs	2/22/19	2/22/19	0.00	0.00	QC 5 - 10		APR 01 2019
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		



Container No: S168039



Part: D3565-1

Job No: 190177-A

Serial No/Batch: S162051

Revision: C

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
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Date: 04/01/19

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					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
160 Powdercoat - 3 Grey Sand - B4B	6 pcs	2/22/19	0.00 0.11		Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
170 QC 3	6 pcs	2/22/19	0.00 0.00		QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
180 Packaging 3-1 - Stock - B4B	6 pcs	2/22/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 -	

BK 19-04-2

START: 10:15 OUT: 320° FINISH: 10:45

DAS
40
9-89

APR 02 2019

				B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	ST 185 APR 02 2019
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
190 QC 21 - SA	6 pcs	2/22/19	0.00 0.00	QC 21 - SA - 21	DAG
				QC 21 - SA - 70	21 APR 02 2019
				QC 21 - SA - 53	9-89

Part Op **120** - (QC8- Inspect parts - second check)
 Descriptions: **130** - (Weld per dwg A/R S.S. rod Batch: _____)
140 - (QC9- Inspect visual per QSI004- Fusion Welds)
150 - (QC5- Inspect part completeness to step on W/O)
160 - (Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3)
170 - (QC3- Inspect Part Finish)
180 - (Identify as per dwg & Stock Location: _____)
190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3009-3	Cup	18 pcs (3 ea)	130-Large Fab - Welded Assy-2- B4B	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
130-Large Fab - Welded Assy-2- B4B	D3009-3	18	22	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearplate(R44)	0.879inches + 0.010 - 0.001	0.889 0.878		
2	Wearplate(R44)	0.750inches ± 0.030	0.780 0.720		
3	Wearplate(R44)	1.000inches ± 0.030	1.030 0.970		
4	Wearplate(R44)	2.000inches ± 0.030	2.030 1.970		
5	Wearplate(R44)	2.250inches ± 0.010	2.260 2.240		
6	Wearplate(R44)	8.120inches ± 0.010	8.130 8.110		
7	Wearplate(R44)	9.620inches ± 0.030	9.650 9.590		
8	Wearplate(R44)	0.063inches ± 0.010	0.073 0.053		

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